

### Processing information

Re-drying: 100 - 150 °C/1 h  
(if required)

Welding positions:



Polarity:



Clean welding area carefully and remove cast skin from base material. Low heat input during welding is required. Therefore weld bead width should not be more than twice of electrode diameter, length max. 10 times. For reducing the tension the weld should be hammered just after welding. When welding with DC, negative-polarity, the seam is clean and flat. With +polarity the heat input is lower and the welding seam is more convex. When welding with AC the appearance is in between.

### Application

Nickel electrode for cold-welding of grey cast iron, malleable iron and cast steel as well as for welding on fatigued casted parts. It is also suitable for the removal of blowholes and the repair of processing defects. The electrode has excellent welding properties even with low amperages. It produces a smooth, intensive flow and low spatter. The slag can be easily removed. The seam surface is soft and also at the transition zone machinable.

### All Weld Metal Mechanical Properties

#### Weld Metal Composition [%]

C	Ni
0,8	B

Tensile Strength Rm [MPa] > 400

Hardness [HB] ≈ 150

### Field



**Characteristic**  
**basic-graphitic-coated,**  
**pure-nickel**  
**core wire**

### Standards

**ISO 1071**  
**E C Ni-C13**  
**AWS A 5.15**  
**E Ni-CI**

### Approvals



### Welding Current, Packaging

Item no.	Dm./Länge [mm]	Amperage [A]	kg/Pack	≈ Piece/Pack	kg/1000 Pc.
00.002.253	2,50/350	80 - 100	1,5	74	20,3
00.002.323	3,25/350	100 - 130	1,5	43	34,9
00.002.403	4,00/350	120 - 160	1,6	30	53,3



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